

*MELT FILTER FOR PURIFYING PLASTIC MELTS*CROSS REFERENCE TO RELATED APPLICATIONS

This application is the US national stage of PCT application PCT/EP2004/014093, filed 10 December 2004, published
5 23 June 2005 as WO2005/056273, and claiming the priority of German patent application 10358672.5 itself filed 12 December 2003, whose entire disclosures are herewith incorporated by reference.

FIELD OF THE INVENTION

10 The invention concerns a melt filter for purifying especially plastic melts discharged by extruders, with a filter disk, ~~which is~~ installed between two plates that form a housing equipped with a filter-element-changing station, that can be rotationally driven by a power-driven ratchet drive, and that has
15 spaces ~~recesses that are~~ separated by ~~web~~ spokes and arranged in ~~[[along]]~~ a circularly annular array ~~[[path]]~~ for holding exchangeable filter elements, ~~which are~~ supported by means of perforated disks against the forces that arise due to the pressure drop that occurs in them in the direction of flow of the
20 plastic melt, and with a melt channel, ~~which~~ passage that passes through the plates in the area of the circular ~~[[path]]~~ array, feeds the melt to the filter elements, and widens toward the filter elements.

Prior-art melt filters are described, for example, in
25 EP 0 114 651 ~~[[B1]]~~. However, the previously known melt filter

has a very large and thus expensive filter disk, whose filter_
element_changing station is also very large, but the surface of
the filter disk against which the melt flows is very small, so
that extremely poor efficiency results. EP 0 569 866 [[A1]] (US
5 5,336,223) has already proposed that the melt ~~channel~~ passage be
widened toward the filter elements, so that the melt to be
filtered can flow against two filter elements at the same time,
but here again, there is no flow against large areas of the
filter elements, so that similarly poor efficiency is obtained.

10 In addition, the teeth on the filter disk have a
relatively large pitch, so that, when the filter disk is rotated
further rotationally stepped, large surfaces of the dirty filter
elements are exchanged for correspondingly large surfaces of
clean filter elements. This results in pressure differences in
15 the cleaned melt which are unacceptable during further processing
of the melt, so that additional pumps are often needed to
guarantee [[a]] constant pressure of the cleaned melt.

It has already been proposed that gear drives that
produce smaller steps be used instead of the sturdy, inexpensive
20 ratchet drive in order to exchange only small filter disk areas
with dirty filter elements for filter disk areas with clean
filters at any given time and thus to ensure constant pressure
constancy. However, expensive rotational drives of this type
constitute an immense cost factor.

25 DE 42 12 928 [[A1]] (5,449,458) has already disclosed a
large-surface cover for a filter disk, but large areas of the

filter disk are still exposed to ambient air when the filter disk is rotated, so that undesired changes in the plastic can occur.

OBJECT OF THE INVENTION

The object ~~[[ive]]~~ of the invention is to ~~specify~~
5 provide a melt filter that is as small as possible, with which hardly any changes occur in the plastic during operation, which guarantees filter element exchange at more or less constant pressure, even at high pressures, and which is nevertheless inexpensive to ~~produce~~ manufacture.

SUMMARY OF THE INVENTION

To this end, it is proposed that the plates completely cover the filter disk, with at least one of the plates being ~~interrupted by~~ cut away at the filter_element_changing station, and that the filter_element_changing station be designed larger
15 than one filter element and smaller than or the same size as two filter elements. This results in ~~the formation of~~ a housing ~~[[which]]~~ that encloses, if possible, the whole filter disk and is better able to withstand the high pressures that are required.

It has been found to be effective for at least one of
20 the plates to have a reversibly movable region that covers the filter_element_changing station, for the filter disk to be completely covered during the operation of the filter and closed snugly toward the filter disk, and for the filter_element_changing station to be uncovered for the filter element change to
25 be carried out during the operation of the filter. On the one hand, the complete covering of the filter disk makes it possible

to ~~realize~~ employ higher pressures, and, on the other hand, it is guaranteed that during the operation no plastic melt adhering to the filter disk comes into contact with the ambient air.

It is advantageous that the ~~given distance~~ angular
5 spacing between filter elements against which the melt is flowing and the filter_element_changing station ~~[[is]]~~ be larger than or the same size as the width of one filter element and a web spoke, and smaller than the width of two filter elements and a web spoke. This guarantees that melt flows against the largest
10 possible surface area of the filter disk with the smallest possible filter changing station without it being possible for melt to be pressed out of the filter_element_changing station.

Due to these optimum relationships between the size of the filter_element_changing station and the surface of the filter
15 disk against which melt is flowing, the filter disk can be made more compact than the prior-art filter disks and yet make a larger effective filter surface available.

It is advantageous if the ratio of the web spoke area against which the melt is flowing to the area of the filter disk
20 through which melt is flowing is less than 18% and greater than 12%. This guarantees that the web spokes are provided with dimensions that still enable them to withstand the high pressures but oppose the melt to be filtered with the least possible surface areas that cannot be used for filtration, so that the
25 greatest possible filter surface area can be effectively realized. In this connection, it has been found to be effective

if the ratio of the ~~web~~ spoke area against which the melt flows, to the area through which the melt flows, is $15 \pm 1\%$.

To be able to guarantee constant pressure during the filter change, it is advantageous that, for each stroke of the ratchet drive, a maximum of 10% of the area of the filter disk against which the plastic melt flows can be exchanged for corresponding filter disk areas with unused filter elements. In this connection, it has been found to be effective if $6 \pm 1\%$ of the filter area ~~can be~~ is exchanged per stroke of the ratchet drive. The exchange of a maximum of 10% of the area of the filter disk, i.e., of the filter elements and the ~~web~~ spokes, against which the plastic melt flows guarantees that approximately constant pressure is present in the filtered melt, and this allows trouble-free further processing of the melt in the downstream machines.

BRIEF DESCRIPTION OF THE DRAWING

The invention will now be explained in greater detail with reference to the drawing in which:

FIG. 1 is a cross section through the filter according to the invention;

FIG. 2 is a small-scale end view of the filter; and

FIG. 3 is a section taken along line IIII--III of FIG.

2.

SPECIFIC DESCRIPTION

The drawing ~~which~~ shows a melt filter 1 that consists of a housing 2, a filter disk 3, and a ratchet drive 4. The

housing 2 is formed by a plate 5, ~~which~~ is connected by fastening devices 6 with another plate 5', whose outline is indicated by a broken line. The plates 5, 5' enclose the filter disk 3 between them and the filter disk 3 is braced against a perforated support disk 15. A filter-element-changing station 7 having a cover 14 is indicated in the plate 5. It is essentially the same size as a single filter element 8. In addition, the plate 5 has a melt ~~channel~~ passage 9, ~~which~~ that widens toward the filter disk 3 in the form of an annular segment 10.

In addition to the filter elements 8, the filter disk 3 has ~~web~~ spokes 11. Teeth 12, which interact with the ratchet drive 4, are ~~arranged along~~ provided on the periphery of the filter disk 3. The ~~web~~ spokes 11 are connected ~~to~~ to a wheel rim 13.

Due to the fact that the filter-element-changing station 7 is selected to be as small as possible, most of the filter disk 3 ~~can be~~ is enclosed by the plates 5. This makes it possible to ~~handle~~ work with the largest possible pressure ~~prevailing in the melt channel~~ passage without the ~~occurrence of~~ clogging of the filter disk 3 jamming in the housing 2. The ~~web~~ spokes 11 and the peripheral wheel rim 13 of the filter disk 3 are supported on the plates 5, 5' and seal the melt ~~channel~~ passage 9 and the annular segment 10 toward the outside.

The annular segment 10 spans the ~~web~~ spokes 11' to 11'''' and the filter elements 8' to 8'''''. In this regard, as a result of the relationships, in accordance with the

invention, between the size of the surface against which the melt is flowing, the distance to the filter_element_changing station, and the size of the filter_element_changing station, an optimum condition is achieved, so that even with a small filter disk 3 at
5 high pressures, the melt can be optimally filtered with a good constant pressure constancy.

~~List of Reference Numbers~~

~~1. melt filter~~

~~2. housing~~

10 ~~3. filter disk~~

~~4. ratchet drive~~

~~5. plate~~

~~6. fastening device~~

~~7. filter element changing station~~

15 ~~8. filter element~~

~~9. melt channel~~

~~10. annular segment~~

~~11. webs~~

~~12. teeth~~

20 ~~13. wheel rim~~